LNP™ THERMOCOMP™ COMPOUND KB006

KB-1006

DESCRIPTION

LNP* THERMOCOMP* KB006 is a compound based on Acetal containing 30% Glass Bead.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	34	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	19.8	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	43	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3990	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	37	MPa	ISO 527
Tensile Strain, break, 5 mm/min	20.4	%	ISO 527
Flexural Stress	65	MPa	ISO 178
Flexural Modulus, 2 mm/min	4320	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	374	J/m	ASTM D 4812
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	311	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	218	°C	ASTM D 648
CTE, -30°C to 30°C, flow	8.3E+01	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	8.3E+01	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	152	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	107	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.64	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	1 – 3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Density	1.64	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Melt Temperature	200 – 215	°C	
Front - Zone 3 Temperature	210 – 220	°C	
Middle - Zone 2 Temperature	195 – 205	°C	
Rear - Zone 1 Temperature	175 – 190	°C	
Mold Temperature	80 – 110	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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